

Work Order ID 82909

April-10-12 2:47:10 PM

ASAP

82909

Page 1

Item ID: D2432

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 206 (24") Bearpaw

Start Date: 10/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/10 Tooling:

Date:

Run Start *NR1*

QC:

Date: * SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

OHmw 1" Blk

(20)

2

M/Jm
12-4-20

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

SL/PO 12/04/27

19

1

PTO

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

SL/PO 12/04/27

19

1

Dart Aerospace Ltd

W/O: 82909		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: Fault Category: machining NCR: Yes No DQA: Date: 12/05/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 12/5/07

NCR: 12-1395		WORK ORDER NON-CONFORMANCE (NCR) 187.42						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/27	130	Face mill hit a bolt one 0.261 Hole is oval. 0.356 / 0.266 RC: OPERATOR ERROR	1204.22 Q51042	SCRAP. + Destroy no Replme	PD 12/04/27	12.04.27 Q51042	12.04.27 Q51042	5 12/04/27
		Qty 1						

NOTE: Date & initial all entries

Work Order ID 82909

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Page 2

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Accept

N900040100

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Required Date: 17/04/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00

151

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

mk 12/04/30

19

(19) 12/5/11

12/5/11

mk 12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:47:14 PM

Page 1

Work Order ID: 82909

82909

Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 10/04/2012

Required Date: 17/04/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	324.5100	3.7	74			

MUHMWB10

UHMW 1" Black

**

Location	Loc Qty	Loc Code
MAT018	3.009994737	
120401	0.00999474	
120972	3	
MAT019	1.5	
118814	1.5	
ST052	320	
121277	20	
121278	300	

121346

121401 7.4

121278 44.4

74

121346 22.2

SM
v2-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82909
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.065x45°	✓		Vern	SL-10
B	5.500	+/-0.030	5.502	✓		~	
C	0.200	+/-0.030	.199	✓		~	
D	0.25 x 45°	+/-0.030	.258x45°	✓		~	
E	R0.250	+/-0.030	.250	✓			
F	0.250	+/-0.010	.255	✓		-	
G	0.625	+/-0.030	.628	✓		~	
H	0.375	+/-0.010	.377	✓		-	
I	0.950	+0.030/0.010	.954	✓		-	
J	19.000	+/-0.030	19.00	✓		m-tape	
K	3.14	+/-0.030	3.14	✓		Vern	SL-10
L	3.28	+/-0.030	3.28	✓		~	
M	Ø0.260	+0.005/-0.000	.260	✓		~	
N	Ø0.93	+/-0.030	.930	✓		-	
O	0.30	+0.030/-0.000	.310	✓		~	
P	23.750	+/-0.030	23.750	✓		m-tape	
Q	7.375	+/-0.030	7.377	✓		HGT	
R	4.250	+/-0.010	4.2750	✓			
S	2.000	+/-0.030	2.002 all	✓			
T	9.000	+/-0.010	9.00	✓			
U	9.000	+/-0.010	9.00	✓			
V	0.375	+/-0.010	.376	✓			

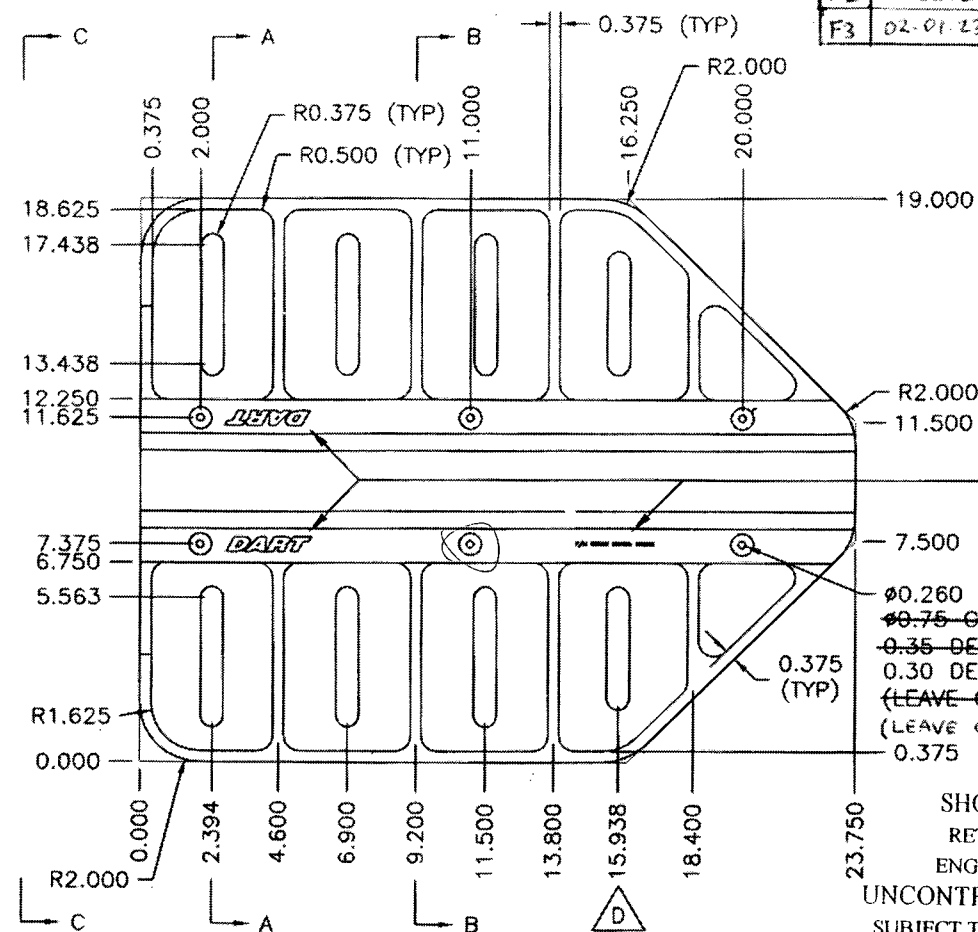
Measured by:	SL	Audited by:	AK	Prototype Approval:	N/A
Date:	12-04-25	Date:	12/04/30	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	TF

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
49.06.17 KE

DART



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
~~0.35 DEEP FROM TOP (MIN.)~~
~~0.30 DEEP FROM BOTTOM~~
~~(LEAVE 0.300 MIN.)~~
(LEAVE 0.650 MIN.)
0.375

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 02909

EFFECTIVE DEOS

9143	
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D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

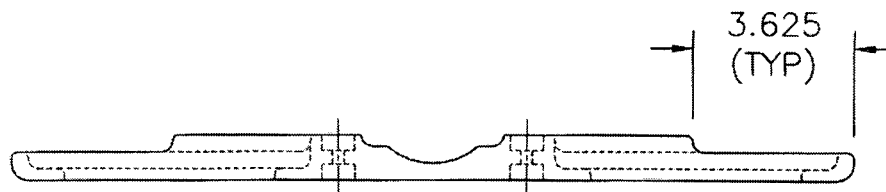
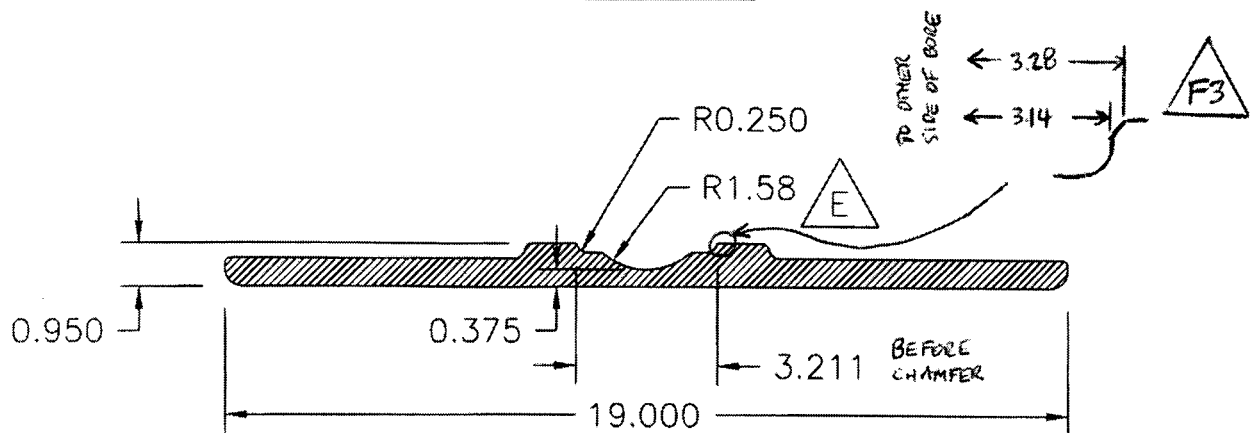
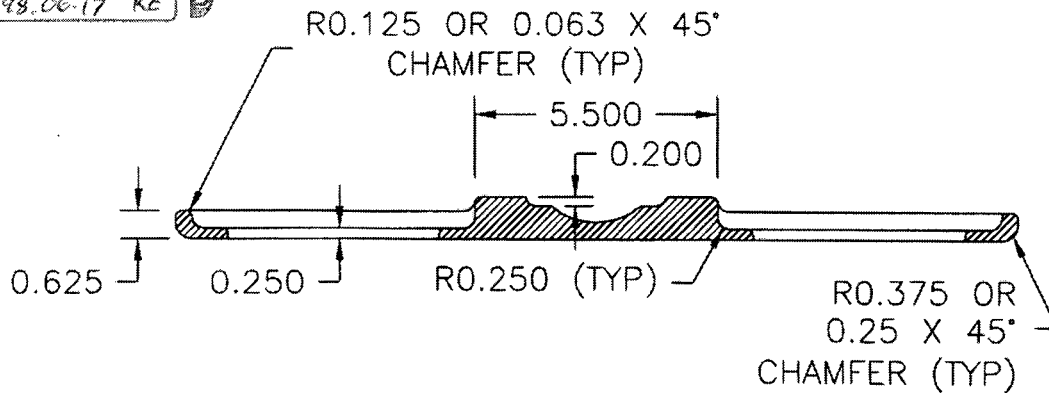
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA	REV. F
CHECKED KE	APPROVED KE	DRAWING NO. D2432	SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



SECTION C-C

02909